

Date: Tuesday, 19/08/2008 4:07:21 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 90 DEGREE BLADE SUPPORT ASSY		
Job Number	: 41510		Part Number	: PB6743001-6743001- pb-147.		
Estimate Number	: 13386		Drawing Number	: B6743001 PAGE24		
P.O. Number	:		Project Number	: N/A		
This Issue	: 19/08/2008 S.O. No. :		Drawing Revision	: B1		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 18/09/2008 Qty: 20 Um: Each		
Previous Run	: 41214					
Written By	:					
Checked & Approved By	: JUP 08.8.20					
Comment	: Est Rev:A 08-06-19 new issue DD verified by:ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S090	6061-T6 .090 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.6241 sf(s)/Unit Total : 12.4824 sf(s)

6061-T6 .090 Sheet

batch: 108595 IB 8-9-3

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001-147

B1

Dwg Rev: B1

Prog Rev: B1 IB 8-9-3

20

2-Deburr if necessary IB 8-9-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-9-3

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



S October 2008

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: Form as per dwg B67-43001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41510

Part Number: PB674300167147

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PB6743001149 Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)
Side Plate

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QS/005 4.1

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 MS21075L3 Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)
Nutplate

14.0 MS20426AD34 RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)
RIVET

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41510

Part Number: PB674300187 147

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

16.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST4UWBA

AS 08/12/04 (2)

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

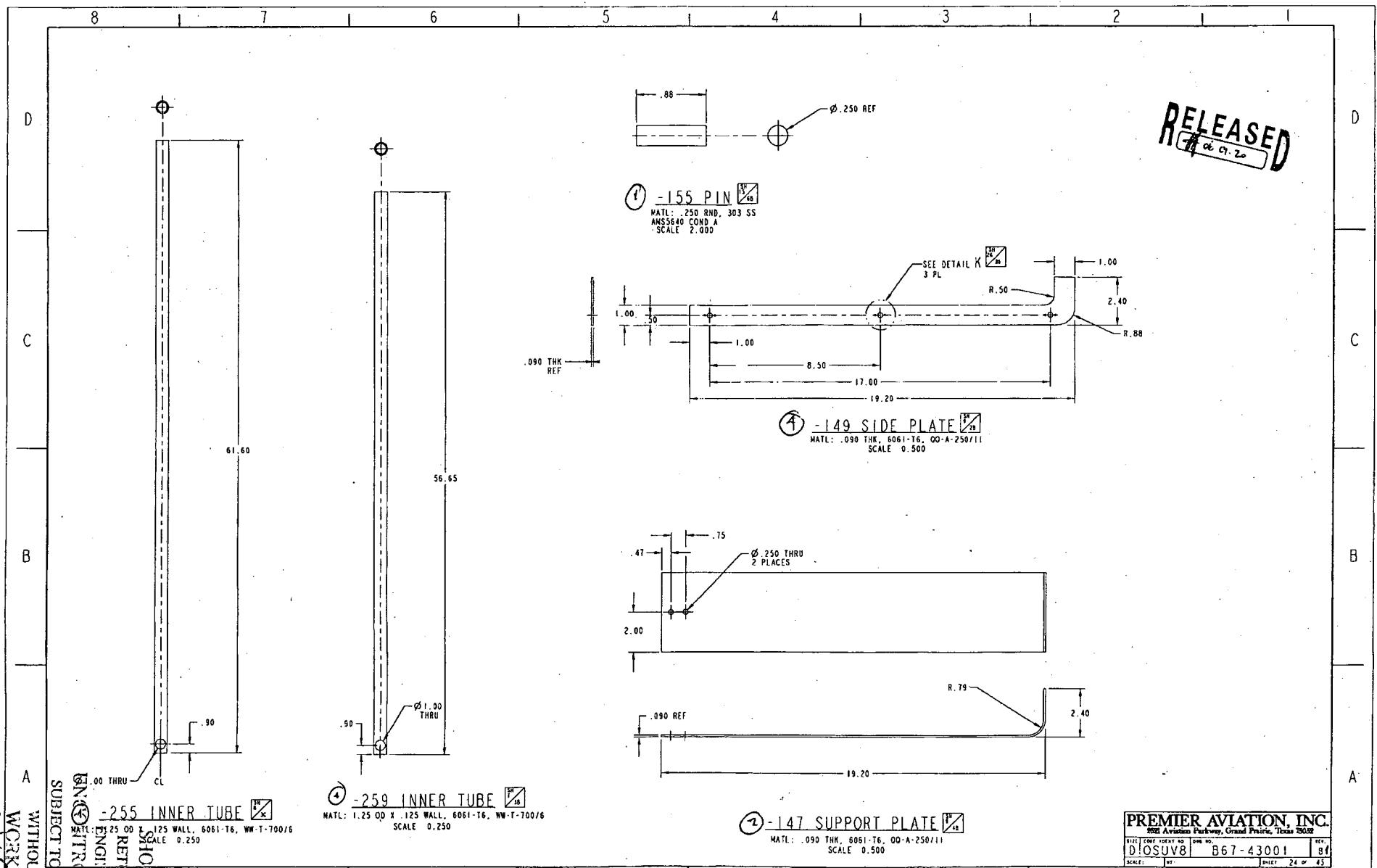
DART AEROSPACE LTD	Work Order:	41510
Description: 90° BLADE SUPPORT ASSY	Part Number:	PB674300-147
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	18	Audited by:	5	Prototype Approval:	N
Date:	8-9-3	Date:	08/09/04	Date:	7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



RELEASED
06-01-20

NO. 41510

ENGINEERING
CONTROLLED COPY
RETRIEVING
TO
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
S/N: 88

PREMIER AVIATION, INC.
1001 Aviation Parkway, Grand Prairie, Texas 75092
REF ID: OSUV8 B67-43001
SCALE: 1:1 DATE: 06-01-2020 BY: 24 or 45

ORIGINAL